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(56) Documents Cited

GB 2092868 A

WO 2001/001855 A1

WO 1988/010058 A

JP 610047686 A

US 4565745 A

US 20010002669 A1

(58) Field of Search

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(54) Abstract Title

Metallised fabric electric circuit

(57) A flexible electric circuit 16 comprises a metallised fabric 14 which is photochemically etched to form a heating element 16. The fabric may be coated with a continuous layer of metal or the individual yarns or fibres may be encapsulated in metal prior to manufacture. The metal may be nickel and the fabric may be woven from polyester threads. Also claimed is a method of manufacturing a flexible circuit. The circuit is particularly suitable for heaters, e.g. clothing and footwear, but may alternatively have control or monitoring applications, e.g. in the medical field or in computers or other electronic equipment.

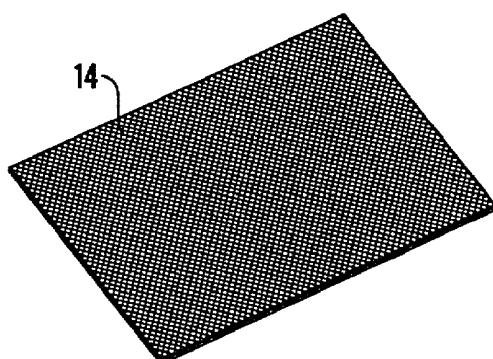


Fig.2a

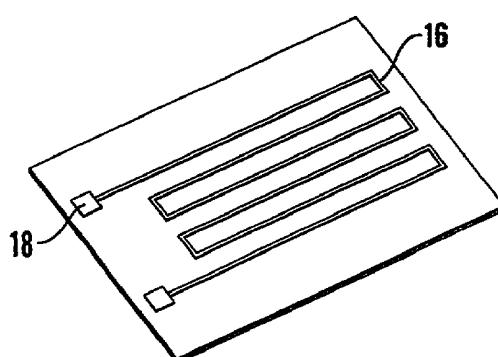


Fig.2b

GB 2 383 197

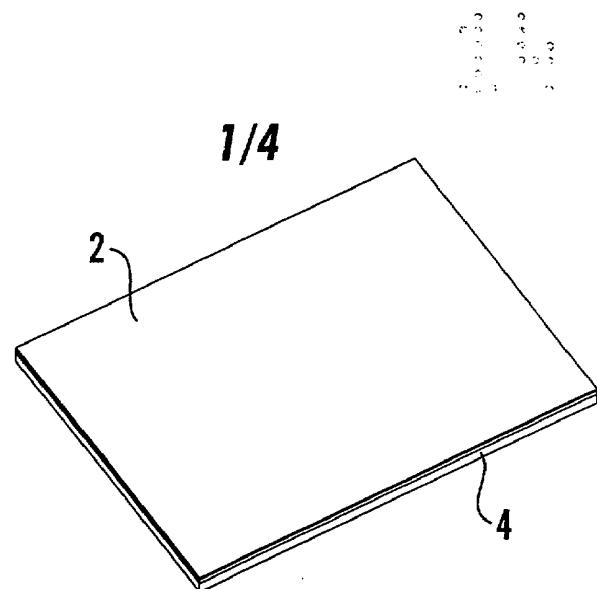


Fig. 1a

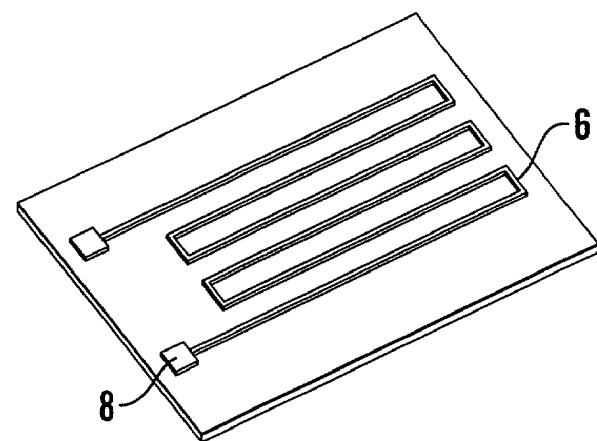


Fig. 1b

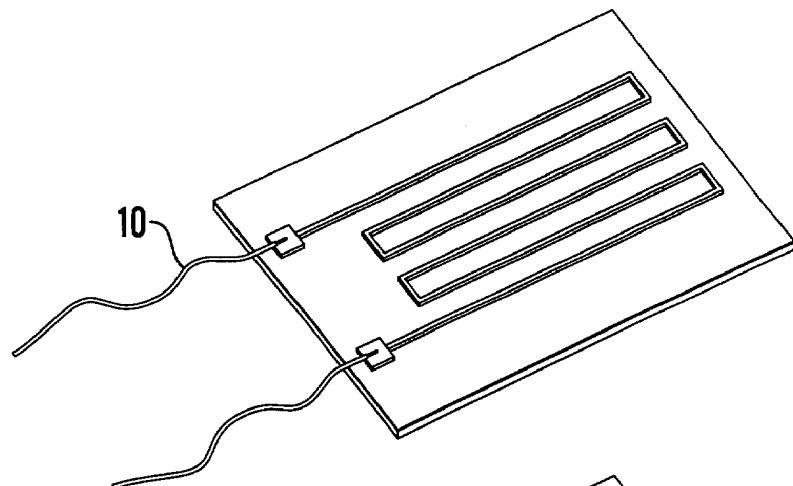


Fig. 1c

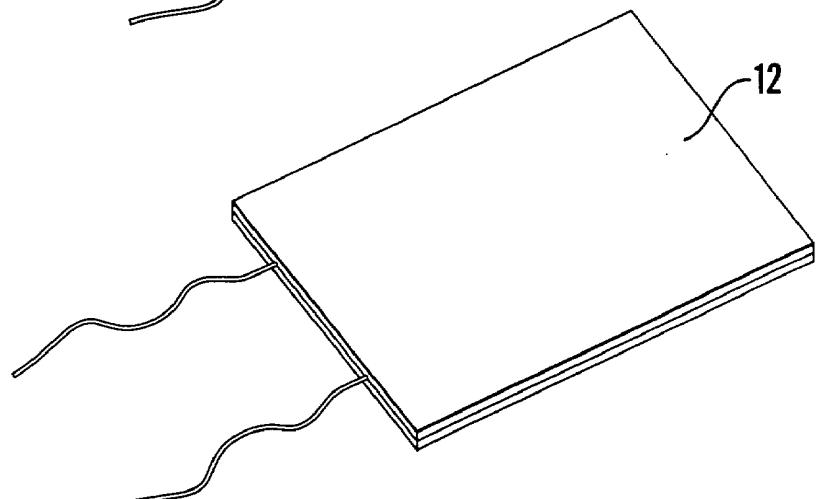


Fig. 1d

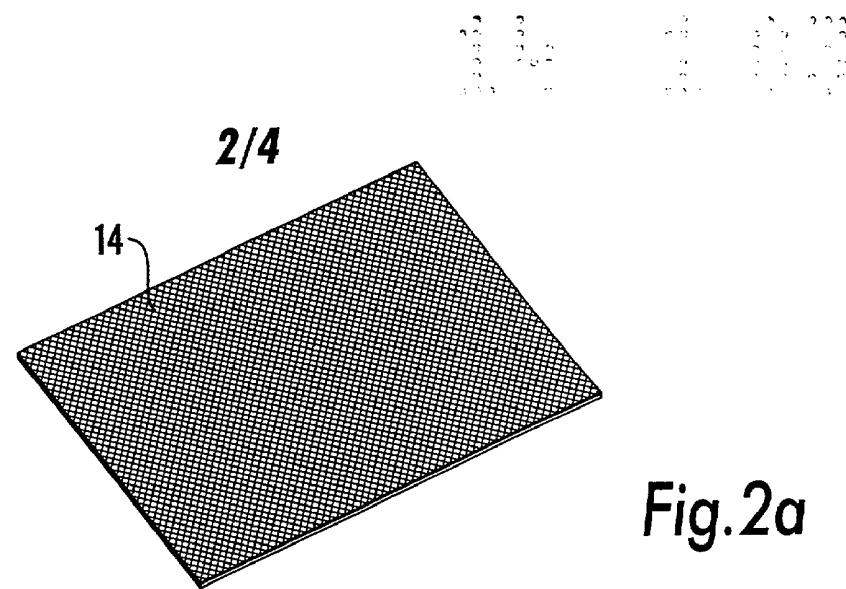


Fig.2a

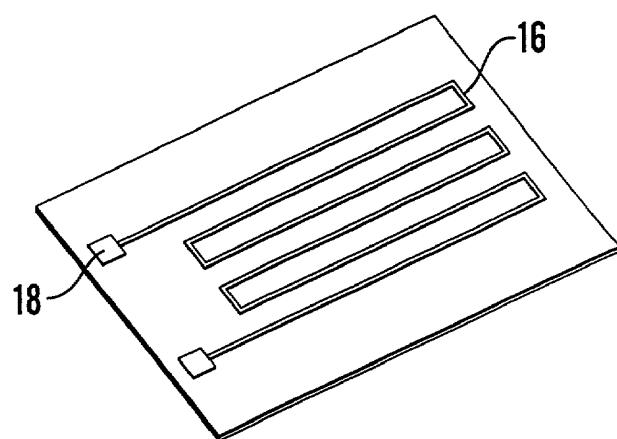


Fig.2b

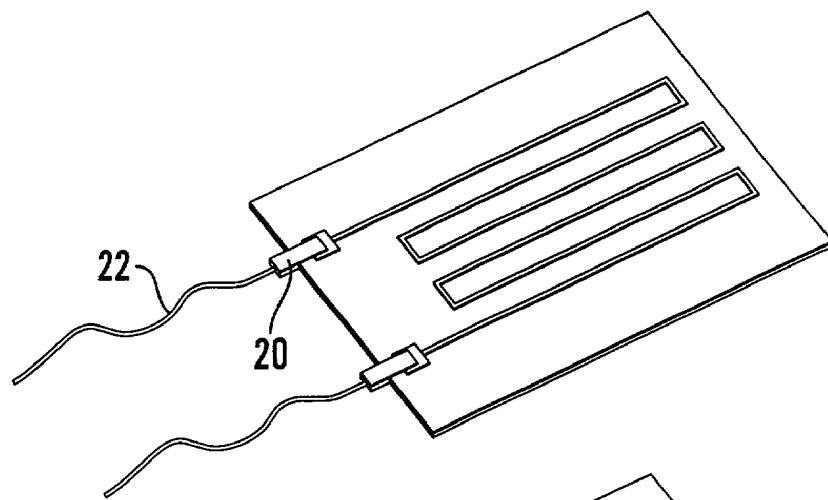


Fig.2c

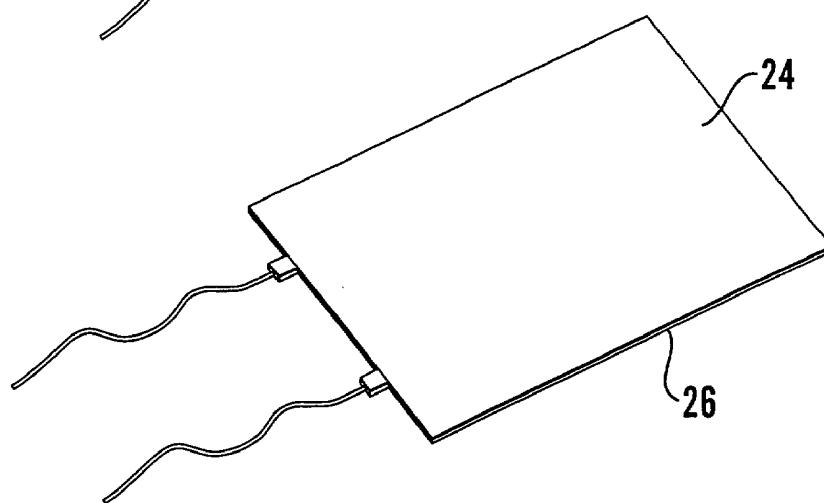


Fig.2d

3/4

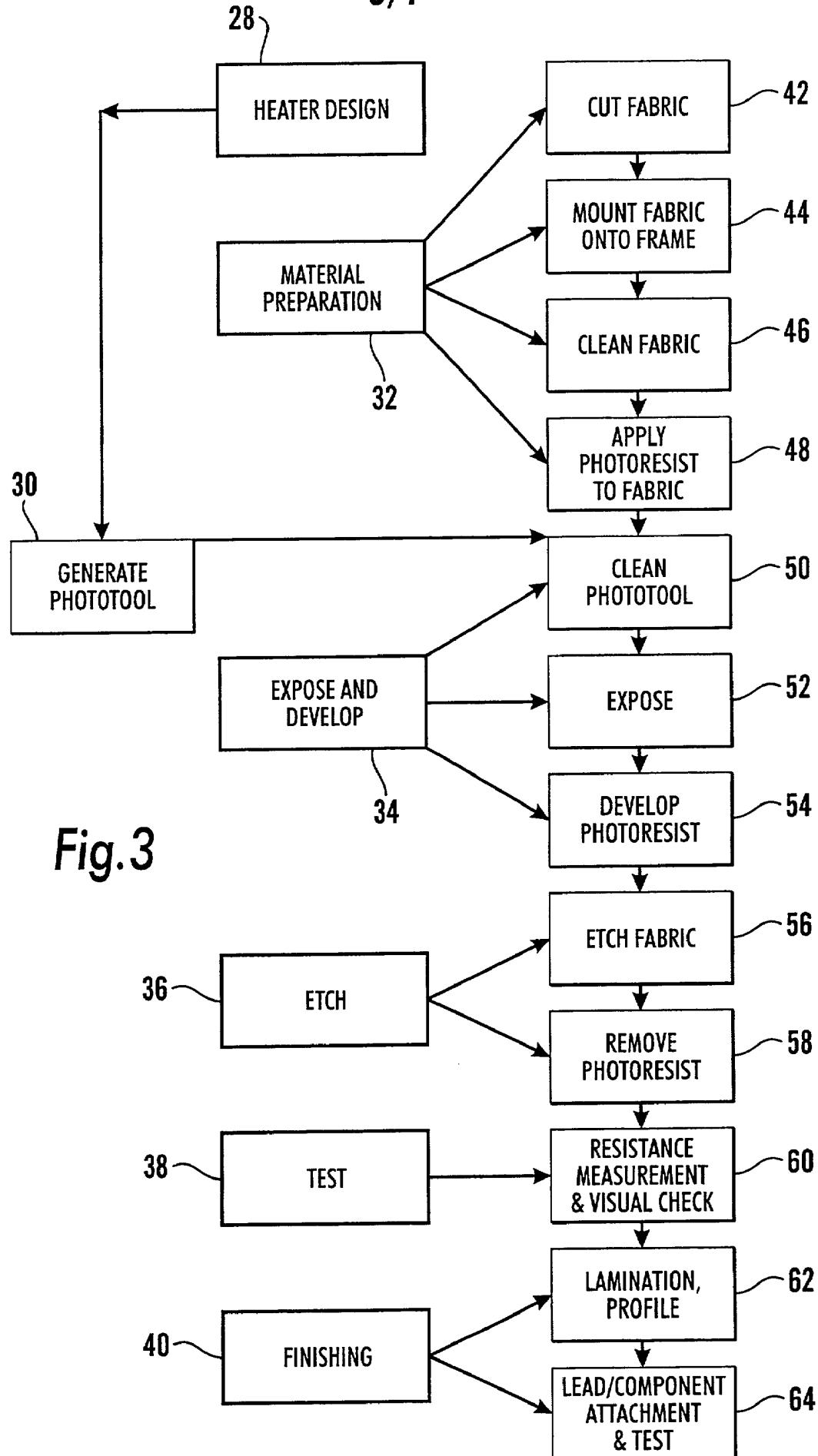


Fig.3

4/4

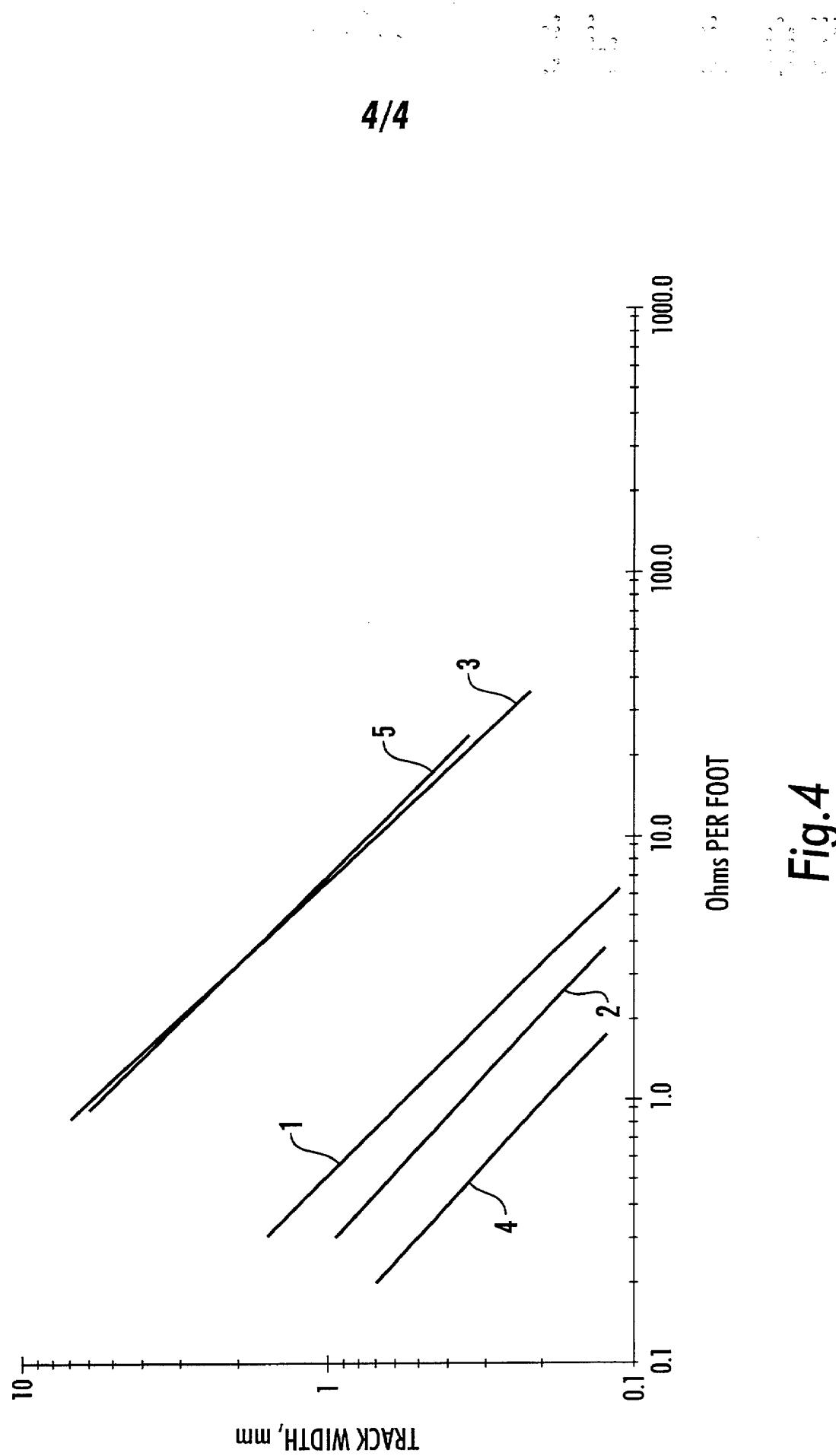


Fig.4

FLEXIBLE ELECTRIC CIRCUIT

This invention relates to flexible electric circuits, and has particular though not exclusive application to such circuits in the form of heaters and/or for incorporation in 5 articles of clothing, footwear and fabric based electrical devices.

The manufacture of flexible heaters by photochemical etching metal foil bonded to thin, flexible electrical insulation materials is a well established practice. Fig. 10 1a shows metal foil 2 bonded to an electrical insulation material 4 by the use of a suitable adhesive. The resulting heater element 6 and termination pads 8 shown in Fig. 1b are formed using conventional photochemical etching techniques. Leadwires 10 (Fig. 1c) are attached to the 15 termination pads 8 by means of crimping, welding, soldering, conductive adhesives or other joining techniques. Electrical insulation is completed by bonding suitable insulation material 12 on top of the etched heater element as shown in Fig. 1d.

20 An alternative way to connect the leadwires 10 involves pre-forming openings in the top insulation layer 12 which is then bonded to the etched heater element 6. Subsequently, the termination pads 8 of the heater element 25 6 are connected to leadwires or connectors using crimping, welding, soldering, conductive adhesives or other joining

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techniques. The electrical insulation is completed by covering the heater element termination and leadwire joint with a patch of insulating material using an appropriate adhesive.

5 The electrical insulation materials used are in sheet form (up to 1mm thick) and are typically non-porous. Common types of flexible insulating materials used are fibre reinforced silicone rubber, polyimide and polyester. Metal sheet (typically 10 μm -500 μm thick) is bonded to the 10 insulating material using an adhesive. Metals and alloys used for heater elements typically have a resistivity which has a low dependence on temperature and include, for example, copper, nichrome, nickel and stainless steel. The resistance of the heater element, and consequently the 15 operating temperature, is controlled by changing the type of metal foil, the thickness of the metal foil or the heater element design.

Other types of flexible heaters available utilise different forms of heating element and include wire-wound 20 elements, interwoven carbon fibre sheets and metallised synthetic fibre sheets such as nickel coated polyester.

It is also known to utilise metallised fabrics and similar mesh structures in the manufacture of flexible heaters, for example as disclosed in GB 2,092,868 and DE 25 3210097. However such structures have total metallisation,

and the electrical resistance is controlled by the metal composition, the density of application and the like.

It would be desirable to be able to provide a flexible electric circuit more conveniently and economically 5 manufactured than heretofore and in which the electrical characteristics, in particular the electrical resistance, can be more easily controlled than heretofore.

According to one aspect of the present invention there is provided a flexible electric circuit comprising a 10 metallised fabric the metal of which is photochemically etched to form the circuit.

It will be appreciated that such an arrangement is distinguished from the prior art in that the metal is modified by photochemical etching to provide circuit 15 elements of chosen configuration and electrical properties.

Preferably the fabric is porous.

The fabric to be etched may be coated with a continuous layer of metal, for example by chemical reduction, by electro-deposition or by sputtering.

20 Alternatively the fabric may comprise yarns and/or fibres the individual yarns and/or fibres being encapsulated in metal prior to manufacture of the fabric.

According to a further aspect of the invention, there is provided a method of manufacturing a flexible electric 25 circuit comprising the steps of providing a metallised

fabric, and photochemically etching the metal to form the circuit.

By way of examples only, embodiments of the invention will now be described in greater detail with reference to 5 the accompanying drawings of which:

Figs. 1a to 1d show the simplified manufacturing steps of a prior art flexible heater;

Figs. 2a to 2d show the simplified manufacturing steps of a flexible heater according to the invention;

10 Fig. 3 is a flow chart of the manufacturing steps of a flexible heater according to the invention;

Fig. 4 is a graph showing the log of the resistance change against track width for a standard element design for various metal foil heater elements and for the element 15 of a heater according to the invention.

Fig. 2a shows a sheet of heat resistant polymeric mesh 14 coated with a continuous layer of metal and which forms the basis for a heater according to the invention.

The mesh 14 can take a variety of different 20 configurations, a typical commercially available metallised woven polymeric mesh being Metalester TM. Such products are woven electroless nickel plated polyester meshes with a variety of thread thicknesses, thread spacings, type of weave and weight of nickel. Threads may typically have a 25 diameter within the range 24 to 600 microns, a thread count

of between 4 and 737 per cm, and a metal coating of varying weight per square metre.

The fabrics may be coated with a continuous layer of metal after manufacture, for example by sputtering, by 5 chemical reduction or by electro-deposition, which results in total encapsulation of all the threads of the mesh in metal. In an alternative mesh, the individual warp and weft threads may be metallised prior to fabric production, for example by sputtering, by chemical reduction or by 10 electro-deposition.

The fundamental novelty of the invention is that the metallised mesh is photochemically etched to form the heater element, a typical element 16 with termination pads 18 being shown in Fig. 2b.

15 Crimp connectors or other suitable flexible substrate connection devices 20 are fixed to the termination pads 18 allowing leadwires 22 to be attached as shown in Fig. 2c, while electrical insulation is completed by bonding insulation material 24,26 to the top and bottom of the 20 heater as shown in Fig. 2d.

Fig. 3 shows in more detail the steps associated with the process of manufacturing an etched flexible heater from metallised woven fabric.

There are six main process steps involved, namely 25 1. design and generation of the phototool (boxes 28,30);

2. material preparation (box 32);
3. exposure and developing (box 34)
4. etching (box 36)
5. testing (box 38)
- 5 6. finishing (box 40)

The material preparation step 32 is divided into the sub-steps of:

- a) cutting the metallised fabric to length (box 42);
- b) mounting the cut fabric onto a hinged frame (box 44),
10 typically 1.5 mm thick brown styrene board, to enable the otherwise flimsy fabric to be more readily handled and to travel flat through the subsequent multi-stage manufacturing process;
- c) cleaning the fabric with a commercial surface cleaning agent (box 46) to assist the adhesion of the
15 lamination of dry film photoresist - if the cleaning agent is not used, and the surface is contaminated, there is a tendency for poor adhesion of the photoresist to the metal to be etched which can result
20 in the etchant undercutting the photoresist and attacking the metal area which forms the required image, in turn reducing the track width and increasing the resistance of the track;
- d) applying the photoresist (box 48) - one method of
25 applying the photoresist is by dip-coating - i.e.

immersing the fabric in a liquid photoresist to ensure a controlled application of liquid photoresist to all parts of the metallised polyester threads and to avoid undercutting of the etched track due to non-
5 application of photoresist to parts of the threads.

The exposure and developing step 34 is divided into the sub-steps of:

- a) cleaning the phototool (box 50);
- b) exposing the photoresist to ultraviolet light (box
10 52), and
- c) developing the image of the heater element on the fabric (box 54).

The etching step 36 is divided into the sub-steps of:

- a) progressively etching away the unrequired metal (box
15 56), and
- b) removing the photoresist to leave the required heater element (box 58).

The resultant flexible heater is then tested, for example by measuring the electrical resistance, and by
20 visual inspection (box 60).

The heater is finished by electrically insulating the porous woven metallised etched fabric, for example by bonding layers of suitable electrically insulating sheet material to each side using a web consisting of low melt
25 fibres - adhesive in the open mesh area can be minimised by

applying a vacuum during lamination - or by dip-coating or paint-spraying the etched fabric with a suitable heat resistant lacquer - again the use of a vacuum after lacquer application will maximise the mesh open area. To further 5 improve the porosity of the heater, the laminated insulating material may be a micro-porous breathable fabric or film. After lamination, the porous heater is profiled by cutting to its final shape (box 62).

The attachment of leadwires and other components such 10 as thermal protection devices complete the product which is then re-tested for electrical performance (box 64).

Clearly the desired electrical characteristics of a heater, and in particular the heat output, will determine the particular metallised woven fabric to be used to 15 manufacture the heater, and the width and length of the element to be photochemically etched on the fabric.

Fig. 4 shows a graph of the log of the track width in mm against the log of the resistance of the track in ohms per foot for a standard element design for each of four 20 conventional etched foil heaters and a heater according to the invention.

The individual graphs in Fig. 4 are:

1. annealed nickel foil of 50 microns thickness;
2. annealed copper foil of 18 microns thickness;

3. annealed stainless steel (Grade 321) of 38 microns thickness;
4. annealed copper foil of 35 microns thickness;
5. Metalester™ MET 25/16 (25 g.m⁻²).

5 It can be seen that product 5, a heater according to the invention, has a resistance substantially the same as that of the stainless steel foil heater 3.

More particularly, the metal, the fibre diameter, the thickness of the metal coating, the spacing of the fibres 10 and the element design are all taken into account to determine the required electrical characteristics.

In the above described example, the threads are typically polymeric, particularly polyester for relatively low temperature applications, although any synthetic or 15 natural fibres may suffice as a base for the product of the invention.

In the invention the flexible electric circuit may be manufactured from fabrics incorporating yarns of the following two classes:

20 (i) Continuous: mono or multi-filaments of indefinite length and including polypropylene, polyethylene, chlorofibres, viscose rayon, di- and tri-acetate, polyester, nylon, aromatic polyamide (Nomex®), poly-paraphenylene terephthalamide (Kevlar®), and

the like. Nomex® and Kevlar® are registered trademarks of E.I. du Pont de Nemours and Company.

(ii) Staple: fibres of definite length twisted, wrapped or otherwise combined, including cotton, linen (flax), jute, wool, mohair, cashmere, angora and other speciality hair fibres, blends of varying composition thereof e.g. 60% cotton/40% polyester and the like.

Fabrics made from the above yarns or fibres (depending on 10 the type of fabric structure) include and are not limited to the following types:

(i) woven

(ii) nonwoven

(iii) knitted - includes warp and weft

15 (iv) composites - laminated structures incorporating but not limited to the following: textiles, coatings, polymer films, membranes, hydrophilic and micro-porous breathable films, metals, ceramics and other materials.

(v) pressed felts

20 (vi) braids

The metal is conveniently nickel, although any resistive metal could be used.

The resultant product is thin, flexible and porous, and can be produced relatively inexpensively.

Flexible heaters according to the invention and in the form of photochemically etched metallised fabric mesh have a variety of applications, and can be incorporated in, for example, mosquito traps, wound care products such as

5 medical bandages and dressings, surgical masks and visors, motorcycle visors, sports equipment visors, outdoor and performance clothing, footwear and articles to be moulded, and can be used as aerospace de-icers. Other applications will be apparent to those skilled in the art.

10 Although described above as heaters, the invention is equally applicable to flexible electric circuits for use other than as heaters.

Such a circuit is photochemically etched from metallised woven fabric as detailed above with respect to

15 the heater element 16, and any additional components that are required are mounted thereon. Such a thin, flexible, porous electric circuit can be embedded into articles of wearable clothing and footwear, for example outdoor and performance clothing, military clothing, medical and sports

20 garments, ski and walking boots, trainers, or be incorporated into other products to enhance their functionality and to enable the control of associated electrical equipment, for example, computers; computer keyboards; telephones; mobile telephones; personnel data

25 organisers; computer mouse; personnel audio; global positioning systems; domestic appliances; TV/videos; hi-fi

and music systems; computer game consoles; electronic musical instruments; toys; lighting; clocks and watches; mosquito traps; personal healthcare products including heart rate and other vital sign monitors, disability and 5 mobility aids; automotive user controls; sports equipment; ski goggles; skis; crash helmets for motorcycles, scooters, bikes, snow sports, motor sports, water sports; sports braces; controls for wearable electronics; educational aids; medical applications such as bed pads and blankets; 10 medical sensors; blood and glucose monitoring sensors and personal protection devices (including alarm systems).

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CLAIMS

1. A flexible electric circuit comprising a metallised fabric the metal of which is photochemically etched to form
5 the circuit.
2. A circuit as claimed in claim 1 in which the fabric is porous.
- 10 3. A circuit as claimed in claim 1 or claim 2 in which the fabric is coated with a continuous layer of metal.
4. A circuit as claimed in claim 1 or claim 2 in which the fabric comprises yarns and/or fibres, the individual
15 yarns and/or fibres being encapsulated in metal prior to manufacture of the fabric.
5. A circuit as claimed in any one of claims 1 to 4 in which the fabric is any one of woven, non-woven, knitted, a
20 laminated composite, pressed felt, braid.
6. A circuit as claimed in any one of claims 1 to 4 in which the fabric is woven from polyester threads and the metal is nickel.

7. A method of manufacturing a flexible electric circuit comprising the steps of providing a metallised fabric, and photochemically etching the metal to form the circuit.

5 8. A flexible electric circuit substantially as described with reference to and as illustrated by Figs. 2 to 4 of the accompanying drawings.



Application No: GB 0228999.9
Claims searched: 1 to 8

Examiner: Gerrie Mullen
Date of search: 21 February 2003

Patents Act 1977 : Search Report under Section 17

Documents considered to be relevant:

Category	Relevant to claims	Identity of document and passage or figure of particular relevance	
X	1-3, 5-7	GB 2092868 A	(Enticknap) see fig 1 heating elements 2, 3; page 1 lines 5 to 50.
X	1-3, 5, 7	WO 01/01855 A1	(Jayaraman et al.) see figs 2 and 6; page 5 lines 15 to 26; page 6 lines 10 to 15; page 17 lines 5 to 20.
X	1, 3, 7	WO 88/10058	(Beauferey) see abstract; fig 1 fabric layers 2, 3, foil 4; page 1 line 10; page 2 lines 1 to 3.
X	1-3, 5, 7	US 2001/0002669 A1	(Arkady et al.) see abstract; fig 1; page 3 paragraph 41.
X	1-3, 5, 7	JP 61047686 A	(Katsuhiro et al.) see title.
A		US 4565745	(Rimvydas)

Categories:

X	Document indicating lack of novelty or inventive step	A	Document indicating technological background and/or state of the art.
Y	Document indicating lack of inventive step if combined with one or more other documents of same category.	P	Document published on or after the declared priority date but before the filing date of this invention.
&	Member of the same patent family	E	Patent document published on or after, but with priority date earlier than, the filing date of this application.

Field of Search:

Search of GB, EP, WO & US patent documents classified in the following areas of the UKC^V:

H1R

Worldwide search of patent documents classified in the following areas of the IPC⁷:

H05B, H05K

The following online and other databases have been used in the preparation of this search report:

EPODOC, WPI, PAJ

Panel-type heating conductor for flexible heat appliances

Publication number: DE3210097
Publication date: 1983-09-29
Inventor:
Applicant: WITTE & SUTOR GMBH (DE)
Classification:
- international: H05B3/34; H05B3/34; (IPC1-7): H05B3/34
- European: H05B3/34
Application number: DE19823210097 19820319
Priority number(s): DE19823210097 19820319

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Abstract of DE3210097

For the purpose of the present invention, panel-type heating conductors are composed of a compact flexible woven fabric made of plastic threads (preferably polyester) whose entire surface is coated with a compact, continuous metal (preferably nickel) layer. Said layer can be produced either by chemical reduction or by electrodeposition. Since the thickness of said metallic coating can be varied within certain limits employing both methods of production, resistance values can be produced, also within certain limits, which are matched to the electrical power consumption of the heating conductor for a given operating voltage. Good reproducibility of the desired resistance value can be achieved by appropriate measurement-controlled implementation of the coating method. The polyester woven fabric preferably used as carrier is composed of prestretched threads and is extremely resistant to mechanical loads, which result in only slight permanent deformation or none at all. Contact is made to such panel-type heating conductors preferably by means of metal gauze strips sewn in on two opposite sides.

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